

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000704**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 18-Mar-2008**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** / **HSR's:** / **NCR's:** /

Item	Title	Detail
1	Major component movement	<p>OBG Production:</p> <p>Fitting and welding T-stiffeners to side plates, Fitting and welding stiffeners to floor beams, Machining, beveling and bending closed-ribs, Fitting closed-ribs to deck panels, ZPMC performed closed-rib welding on 2 PMT tests for Gentries 1 and 2, and Deck Plate DP083-001, DP272-001 and DP216-001. Repair required to root pass of DP083-001 (see Other Important Observations), Splice welding Side Plates in OBG Assembly Shop.</p> <p>Tower Production:</p> <p>Cutting Skin Plates Heat straightening diaphragm plates, Fit-up and welding diaphragm plates.</p> <p>77m Tower Mock-up:</p> <p>No work observed.</p> <p>89m Tower Mock-up:</p> <p>Installing new lugs on vertical stiffeners to diaphragm. QA observed 3 of the 4 tack welds on one lug were cracked.</p> <p>114m Tower Mock-up:</p> <p>Removing temporary stabbing guides.</p>
2	Key conversations	<p>QA spoke with Art Peterson regarding the Macro Testing. Mr. Peterson stated ZPMC is currently 4 days behind on the preparation on macro samples. These macro samples are currently being prepared by ZPMC. The quality of the macros is not sufficient in some cases and a better etch is required. Mr. Peterson stated he spoke with ABF QCM Steve Lawton and ABF Fabrication Manager Dave Williams regarding the macro quality and</p>

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they are working with ZPMC to improve the quality.

ABF QCM Steve Lawton informed QA that ZPMC intends to perform PMT tests at 0800 tomorrow. Mr. Lawton stated the intention was to completely weld the PMT prior to beginning any production welding. Visual inspection, Ultrasonic Testing and macro selection, preparation and evaluation are to take place concurrently with production.

3 Other important observations

ABF QCM Steve Lawton informed QA of a repair to the GMAW root pass on Deck Panel DP083-001, weld joint 6. The weld had approximately 40mm where the weld was not fused to the bevel face of the closed-rib. ABF QC Warren Buehler stated the repair process would be to re-prepare the area by grinding to approximate the original groove design and re-weld with using the GMAW on the gantry. QA stated this would be acceptable and asked that a CWR be submitted to document the repair and method, since an in-process repair procedure has not been approved.

QA went with ABF QCM Steve Lawton to the rolled shape material yard to verify heat numbers on some 203 x 203 x 19 angle from a bundle marked by ZPMC as Heat Number 5-09969. QA had removed mill tags which had been painted over from two of the angle and soaked them in solvent overnight to remove the paint. After removing the paint QA observed that one of the tags had Heat Number 5-09969, but that the other tag was Heat Number 5-09968. The bundles were marked as 5-09969. Mr. Lawton agreed that this causes further doubt in the markings put on the material by ZPMC.

4 Quality Assurance Inspectors per shift Approximately 50% of the QA staff was performing Quality Control functions.

Inspected By: McClary, David

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer
